

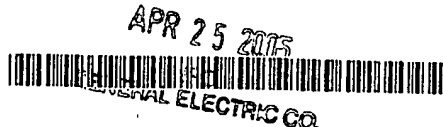
(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization  
International Bureau



(43) International Publication Date  
27 June 2002 (27.06.2002)

PCT



(10) International Publication Number  
**WO 02/50185 A2**

(51) International Patent Classification<sup>7</sup>: C08L 69/00

(21) International Application Number: PCT/US01/51186

(22) International Filing Date:  
13 November 2001 (13.11.2001)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:  
09/742,908 20 December 2000 (20.12.2000) US  
09/742,826 20 December 2000 (20.12.2000) US

(71) Applicant: **GENERAL ELECTRIC COMPANY**  
[US/US]; 1 River Road, Schenectady, NY 12345 (US).

(72) Inventors: **BLACKBURN, Kirk, J.**; 4800 East Blackford Road, Mount Vernon, IN 47620 (US). **GALLUCI, Robert, Russell**; 1109 Tanglewood Drive, Mount Vernon, IN 47620 (US). **GEORGIEV, Emil, Markov**; 10 Thomas Drive, Wyandskill, NY 12198 (US).

(74) Agents: **WINTER, Catherine, J. et al.**; General Electric Company, 3135 Easton Turnpike W3C, Fairfield, CT 06431 (US).

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, UZ, VN, YU, ZA, ZW.

(84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

**Published:**

— without international search report and to be republished upon receipt of that report

*For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.*

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**WO 02/50185 A2**

(54) Title: FLAME RETARDANT POLYCARBONATE RESIN/ABS GRAFT COPOLYMER BLENDS

(57) Abstract: A thermoplastic resin composition contains an aromatic carbonate resin, a rubber modified graft copolymer comprising a discontinuous rubber phase dispersed in a continuous rigid thermoplastic phase, wherein at least a portion of the rigid thermoplastic phase is chemically grafted to the rubber phase, and a flame retarding amount of an alkali metal or alkaline earth metal salt of an alkylbenzenesulfonic acid flame retardant.

FLAME RETARDANT POLYCARBONATE RESIN/ABS GRAFT  
COPOLYMER BLENDS

FIELD OF THE INVENTION

The invention relates to flame-retardant polycarbonate resin/ABS graft copolymer blends that exhibit improved performance.

BRIEF DESCRIPTION OF THE RELATED ART

Flame retardant thermoplastic compositions that contain an aromatic polycarbonate resin and a benzenesulfonic acid salt have been found to exhibit good flame retardancy, see for example U.S. Patent Number 4,220,583.

Aromatic polycarbonate resin has been found to exhibit good flame retardancy in the presence of an arylsulfone sulfonic acid salt, see for example U.S. Patent Number 3,948,851.

Flame retardant thermoplastic resin compositions that contain an aromatic polycarbonate resin, an ABS graft copolymer, a fluoropolymer and an organophosphate flame retardant are known and have been found to exhibit good flame retardancy and good heat resistance, see, for example, coassigned U.S. Patent Number 5,204,394.

Flame retardant resin compositions that exhibit low melt viscosity and impart improved aesthetic appearance, particularly, improved resistance to streaking, and improved physical properties, particularly, improved resistance to edge cracking, to articles molded therefrom are desired.

SUMMARY OF THE INVENTION

In one embodiment the thermoplastic resin composition of the present invention comprises:

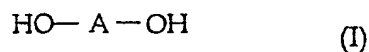
- (a) an aromatic polycarbonate resin,
- (b) a rubber modified graft copolymer comprising a discontinuous rubber phase dispersed in a continuous rigid thermoplastic phase, wherein at least a portion of the rigid thermoplastic phase is chemically grafted to the rubber phase
- (c) a flame retarding amount of an alkali metal or alkaline earth metal salt of a sulfonic acid compound.

#### DETAILED DESCRIPTION OF THE INVENTION

PC / ABS Components. In a preferred embodiment, the thermoplastic resin composition of the present invention comprises, based on 100 parts by weight ("pbw") of thermoplastic resin composition, from 55 to 80 pbw, more preferably from 50 to 90 pbw, even more preferably from 40 to 96 pbw, of the aromatic polycarbonate resin, from 14 to 39 pbw, more preferably from 8 to 48 pbw, even more preferably from 4 to 59 pbw, of the rubber modified graft copolymer and from 0 to 20 pbw, more preferably from 2 to 15 pbw, even more preferably from 6 to 12 pbw, of the organophosphate flame retardant.

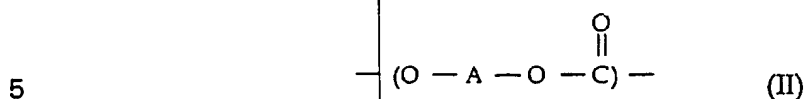
Aromatic polycarbonate resins suitable for use as the polycarbonate resin component of the thermoplastic resin composition of the present invention are known compounds whose preparation and properties have been described, see, generally, U.S. Patent Nos. 3,169,121, 4,487,896 and 5,411,999, the respective disclosures of which are each incorporated herein by reference.

In a preferred embodiment, the aromatic polycarbonate resin component of the present invention is the reaction product of a dihydric phenol according to the structural formula (I):



wherein A is a divalent aromatic radical,

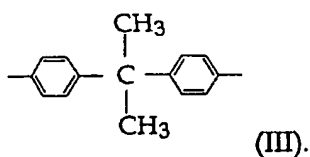
with a carbonate precursor and contains structural units according to the formula (II):



wherein A is defined as above.

As used herein, the term "divalent aromatic radical" includes those divalent radicals containing a single aromatic ring such as phenylene, those divalent radicals containing a condensed aromatic ring system such as, for example, naphthlene, those divalent radicals containing two or more aromatic rings joined by a non-aromatic linkage, such as for example, an alkylene, alkylidene or sulfonyl group, any of which may be substituted at one or more sites on the aromatic ring with, for example, a halo group or (C<sub>1</sub>-C<sub>6</sub>)alkyl group.

In a preferred embodiment, A is a divalent aromatic radical according to the formula (III):



Suitable dihydric phenols include, for example, one or more of 2, 2-bis-(4-hydroxyphenyl) propane ("bisphenol A"), 2,2-bis(3,5-dimethyl-4-hydroxyphenyl)propane, bis(4-hydroxyphenyl) methane, 4,4-bis(4-hydroxyphenyl)heptane, 3,5,3',5'-tetrachloro-4,4'-dihydroxyphenyl)propane,

2,6-dihydroxy naphthalene, hydroquinone, 2,4'-dihydroxyphenyl sulfone. In a highly preferred embodiment, the dihydric phenol is bisphenol A.

The carbonate precursor is one or more of a carbonyl halide, a carbonate ester or a haloformate. Suitable carbonyl halides include, for example, carbonyl bromide and carbonyl chloride. Suitable carbonate esters include, such as for example, diphenyl carbonate, dichlorophenyl carbonate, dinaphthyl carbonate, phenyl tolyl carbonate and ditolyl carbonate. Suitable haloformates include, for example, bishaloformates of dihydric phenols, such as, for example, hydroquinone, or glycols, such as, for example, ethylene glycol, neopentyl glycol. In a highly preferred embodiment, the carbonate precursor is carbonyl chloride.

Suitable aromatic polycarbonate resins include linear aromatic polycarbonate resins, branched aromatic polycarbonate resins. Suitable linear aromatic polycarbonates resins include, e.g., bisphenol A polycarbonate resin. Suitable branched polycarbonates are known and are made by reacting a polyfunctional aromatic compound with a dihydric phenol and a carbonate precursor to form a branched polymer, see generally, U. S. Patent Nos. 3,544,514, 3,635,895 and 4,001,184, the respective disclosures of which are incorporated herein by reference. The polyfunctional compounds are generally aromatic and contain at least three functional groups which are carboxyl, carboxylic anhydrides, phenols, haloformates or mixtures thereof, such as, for example, 1,1,1-tri(4-hydroxyphenyl)ethane, 1,3,5-trihydroxybenzene, trimellitic anhydride, trimellitic acid, trimellityl trichloride, 4-chloroformyl phthalic anhydride, pyromellitic acid, pyromellitic dianhydride, mellitic acid, mellitic anhydride, trimesic acid, benzophenonetetracarboxylic acid, benzophenone-tetracarboxylic dianhydride. The preferred polyfunctional aromatic compounds are 1,1,1-tri(4-hydroxyphenyl)ethane, trimellitic anhydride or trimellitic acid or their haloformate derivatives.

In a preferred embodiment, the polycarbonate resin component of the present invention is a linear polycarbonate resin derived from bisphenol A and phosgene.

5 In a preferred embodiment, the weight average molecular weight of the polycarbonate resin is from about 10,000 to about 200,000 grams per mole ("g/mol"), as determined by gel permeation chromatography relative to polystyrene. Such resins typically exhibit an intrinsic viscosity of about 0.3 to about 1.5 deciliters per gram in methylene chloride at 25°C.

10 Polycarbonate resins are made by known methods, such as, for example, interfacial polymerization, transesterification, solution polymerization or melt polymerization.

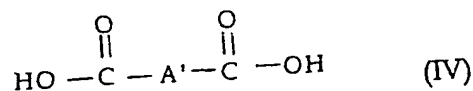
Copolyester-carbonate resins are also suitable for use as the aromatic polycarbonate resin component of the present invention. Copolyester-carbonate resins suitable for use as the aromatic polycarbonate resin  
15 component of the thermoplastic resin composition of the present invention are known compounds whose preparation and properties have been described, see, generally, U.S. Patent Nos. 3,169,121, 4,430,484 and 4,487,896, the respective disclosures of which are each incorporated herein by reference.

20 Copolyester-carbonate resins comprise linear or randomly branched polymers that contain recurring carbonate groups, carboxylate groups and aromatic carbocyclic groups in the polymer chain, in which at least some of the carbonate groups are bonded directly to the ring carbon atoms of the aromatic carbocyclic groups.

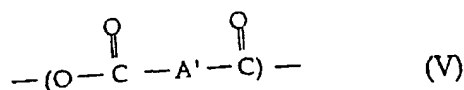
25 In a preferred embodiment, the copolyester-carbonate resin component of the present invention is derived from a carbonate precursor, at least one dihydric phenol and at least one dicarboxylic acid or dicarboxylic acid

equivalent. In  
to the form

a preferred embodiment, the dicarboxylic acid is one according  
ula (IV):



wherein A' is alkylene, alkylidene, cycloaliphatic or aromatic and is  
preferably a non-substituted phenylene radical or a substituted phenylene  
radical that is substituted at one or more sites on the aromatic ring, wherein  
each of such substituent groups is independently (C<sub>1</sub>-C<sub>6</sub>) alkyl, and the  
copolyester carbonate resin comprises first structural units according to  
formula (IV) above and second structural units according to formula (V):



wherein A' is defined as above.

Suitable carbonate precursors and dihydric phenols are those disclosed  
above.

Suitable dicarboxylic acids, include, for example, phthalic acid,  
isophthalic acid, terephthalic acid, dimethyl terephthalic acid, oxalic acid,  
malonic acid, succinic acid, glutaric acid, adipic acid, pimelic acid, suberic  
acid, azelaic acid, sebacic acid, dimethyl malonic acid, 1,12-dodecanoic acid,  
cis-1,4-cyclohexane dicarboxylic acid, trans-1,4-cyclohexane dicarboxylic acid,  
4,4'-bisbenzoic acid, naphthalene-2,6-dicarboxylic acid. Suitable dicarboxylic  
acid equivalents include, for example, anhydride, ester or halide derivatives  
of the above disclosed dicarboxylic acids, such as, for example, phthalic  
anhydride, dimethyl terephthalate, succinyl chloride.

and embodiment, the dicarboxylic acid is an aromatic more preferably one or more of terephthalic acid and

1.

a preferred embodiment, the ratio of ester bonds to carbonate bonds in the copolyester carbonate resin is from 0.25 to 0.9 ester bonds per carbonate bond.

In a preferred embodiment, the copolyester-carbonate copolymer has a weight average molecular weight of from about 10,000 to about 200,000 g/mol.

10 Copolyester-carbonate resins are made by known methods, such as, for example, interfacial polymerization, transesterification, solution polymerization or melt polymerization.

In a polycarbonate-containing blend there may an improvement in melt flow and/or other physical properties when one molecular weight grade of a polycarbonate is combined with a proportion of a relatively lower molecular weight grade of similar polycarbonate. Therefore, the present invention encompasses compositions comprising only one molecular weight grade of a polycarbonate and also compositions comprising two or more molecular weight grades of polycarbonate. When two or more molecular weight grades of polycarbonate are present, then the weight average molecular weight of the lowest molecular weight polycarbonate is about 10% to about 95%, preferably about 40% to about 85%, and more preferably about 60% to about 80% of the weight average molecular weight of the highest molecular weight polycarbonate. In one representative, non-limiting embodiment polycarbonate-containing blends include those comprising a polycarbonate with weight average molecular weight between about 28,000 and about 32,000 combined with a polycarbonate with weight average



molecular weight between about 16,000 and about 26,000. When two or more molecular weight grades of polycarbonate are present, the weight ratios of the various molecular weight grades may range from about 1 to about 99 parts of one molecular weight grade and from about 99 to about 1 parts of any other molecular weight grades. A mixture of two molecular weight grades polycarbonate is often preferred, in which case the weight ratios of the two grades may range from about 99:1 to about 1:99, preferably from about 80:20 to about 20:80, and more preferably from about 70:30 to about 50:50. Since not all manufacturing processes for making a polycarbonate are capable of making all molecular weight grades of that constituent, the present invention encompasses compositions comprising two or more molecular weight grades of polycarbonate in which each polycarbonate is made by a different manufacturing process. In one particular embodiment the instant invention encompasses compositions comprising a polycarbonate made by an interfacial process in combination with a polycarbonate of different weight average molecular weight made by a melt process.

Rubber modified thermoplastic resins suitable for use as the rubber modified thermoplastic resin of the present invention are those rubber modified thermoplastic resins that are made by a bulk or, synonymously, mass, polymerization process and that comprise a discontinuous rubber phase dispersed in a continuous rigid thermoplastic phase, wherein at least a portion of the rigid thermoplastic phase is chemically grafted to the rubber phase.

Suitable rubbers for use in making the rubber phase are those rubber polymers having a glass transition temperature ( $T_g$ ) of less than or equal to 25°C, more preferably less than or equal to 0 °C, and even more preferably less than or equal to -30°C. As referred to herein, the  $T_g$  of a polymer is the  $T_g$  value of polymer as measured by differential scanning calorimetry

(heating rate 20°C/minute, with the  $T_g$  value being determined at the inflection point).

5 In a preferred embodiment, the rubber comprises a linear polymer having structural units derived from one or more conjugated diene monomers.

Suitable conjugated diene monomers include, e.g., 1,3-butadiene, isoprene, 1,3-heptadiene, methyl-1,3-pentadiene, 2,3-dimethylbutadiene, 2-ethyl-1,3-pentadiene, 1,3-hexadiene, 2,4-hexadiene, dichlorobutadiene, bromobutadiene and dibromobutadiene as well as mixtures of conjugated  
10 diene monomers. In a preferred embodiment, the conjugated diene monomer is 1,3-butadiene.

The rubber may, optionally, include structural units derived from one or more copolymerizable monoethylenically unsaturated monomers selected from (C<sub>2</sub>-C<sub>8</sub>)olefin monomers, vinyl aromatic monomers and  
15 monoethylenically unsaturated nitrile monomers and (C<sub>1</sub>-C<sub>12</sub>)alkyl (meth)acrylate monomers.

As used herein, the term "(C<sub>2</sub>-C<sub>8</sub>)olefin monomers" means a compound having from 2 to 8 carbon atoms per molecule and having a single site of ethylenic unsaturation per molecule. Suitable (C<sub>2</sub>-C<sub>8</sub>)olefin monomers  
20 include, e.g., ethylene, propene, 1-butene, 1-pentene, heptene.

Suitable vinyl aromatic monomers include, e.g., styrene and substituted styrenes having one or more alkyl, alkoxy, hydroxyl or halo substituent group attached to the aromatic ring, including, e.g.,  $\alpha$ -methyl styrene, p-methyl styrene, vinyl toluene, vinyl xylene, trimethyl styrene, butyl  
25 styrene, chlorostyrene, dichlorostyrene, bromostyrene, p-hydroxystyrene, methoxystyrene and vinyl-substituted condensed aromatic ring structures,

such as, e.g., vinyl naphthalene, vinyl anthracene, as well as mixtures of vinyl aromatic monomers.

As used herein, the term "monoethylenically unsaturated nitrile monomer" means an acyclic compound that includes a single nitrile group and a single site of ethylenic unsaturation per molecule and includes, e.g., acrylonitrile, methacrylonitrile,  $\alpha$ -chloro acrylonitrile.

As used herein, the term "(C<sub>1</sub>-C<sub>12</sub>)alkyl" means a straight or branched alkyl substituent group having from 1 to 12 carbon atoms per group and includes, e.g., methyl, ethyl, n-butyl, sec-butyl, t-butyl, n-propyl, iso-propyl, pentyl, hexyl, heptyl, octyl, nonyl, decyl, undecyl and dodecyl. and the terminology "(meth)acrylate monomers" refers collectively to acrylate monomers and methacrylate monomers. Suitable (C<sub>1</sub>-C<sub>12</sub>)alkyl (meth)acrylate monomers include (C<sub>1</sub>-C<sub>12</sub>)alkyl acrylate monomers, e.g., ethyl acrylate, butyl acrylate, iso-pentyl acrylate, n-hexyl acrylate, 2-ethyl hexyl acrylate, and their (C<sub>1</sub>-C<sub>12</sub>)alkyl methacrylate analogs such as, e.g., methyl methacrylate, ethyl methacrylate, propyl methacrylate, iso-propyl methacrylate, butyl methacrylate, hexyl methacrylate, decyl methacrylate.

In a first preferred embodiment, the rubber is a polybutadiene homopolymer.

In an alternative preferred embodiment, the rubber is a copolymer, preferably a block copolymer, comprising structural units derived from one or more conjugated diene monomers and up to 50 percent by weight ("wt%") structural units derived from one or more monomers selected from vinyl aromatic monomers and monoethylenically unsaturated nitrile monomers, such as, for example, a styrene-butadiene copolymer, an acrylonitrile-butadiene copolymer or a styrene-butadiene-acrylonitrile copolymer.

In a highly preferred embodiment, the rubber is a styrene-butadiene block copolymer that contains from 50 to 95 wt% structural units derived from butadiene and from 5 to 50 wt% structural units derived from styrene.

5 The elastomeric phase is made by aqueous emulsion polymerization in the presence of a free radical initiator, a polyacid surfactant and, optionally, a chain transfer agent and coagulated to form particles of elastomeric phase material.

Suitable initiators include conventional free radical initiators such as, e.g., an organic peroxide compound, such as e.g., benzoyl peroxide, a  
10 persulfate compound, such as, e.g., potassium persulfate, an azonitrile compound such as, e.g., 2,2'-azobis-2,3,3-trimethylbutyronitrile, or a redox initiator system, such as, e.g., a combination of cumene hydroperoxide, ferrous sulfate, tetrasodium pyrophosphate and a reducing sugar or sodium formaldehyde sulfoxylate.

15 Suitable chain transfer agents include, for example, a (C<sub>9</sub>-C<sub>13</sub>) alkyl mercaptan compound such as nonyl mercaptan, t-dodecyl mercaptan.

In a preferred embodiment, the emulsion polymerized particles of elastomeric phase material have a weight average particle size of 50 to 800 nanometers ("nm"), more preferably, of from 100 to 500 nm, as measured by  
20 light transmission. The size of emulsion polymerized elastomeric particles may optionally be increased by mechanical, colloidal or chemical agglomeration of the emulsion polymerized particles, according to known techniques. In another preferred embodiment the emulsion polymerization is carried out in the presence of an amount of a chain transfer agent effective  
25 to provide a rubber having a swell index of greater than 15.

The rigid thermoplastic resin phase comprises one or more thermoplastic polymers and exhibits a  $T_g$  of greater than 25°C, preferably greater than or equal to 90°C and even more preferably greater than or equal to 100°C.

5           In a preferred embodiment, the rigid thermoplastic phase comprises one or more polymers each having structural units derived from one or more monomers selected from the group consisting of (C<sub>1</sub>-C<sub>12</sub>)alkyl (meth)acrylate monomers, vinyl aromatic monomers and monoethylenically unsaturated nitrile monomers.

10           Suitable vinyl aromatic monomers and monoethylenically unsaturated nitrile monomers and of (C<sub>1</sub>-C<sub>12</sub>) alkyl (meth)acrylate monomers are those set forth above in the description of the rubber phase.

          In a preferred embodiment, the rigid thermoplastic resin phase comprises a vinyl aromatic polymer having first structural units derived from  
15           one or more vinyl aromatic monomers, preferably styrene, and having second structural units derived from one or more monoethylenically unsaturated nitrile monomers, preferably acrylonitrile. More preferably, the rigid phase comprises from 55 to 99 wt%, still more preferably 60 to 90 wt%, structural  
20           units derived from styrene and from 1 to 45 wt%, still more preferably 10 to 40 wt%, structural units derived from acrylonitrile.

          The amount of grafting that takes place between the rigid thermoplastic phase and the rubber phase varies with the relative amount and composition of the rubber phase. In a preferred embodiment, from 10 to 90 wt%, preferably from 25 to 60 wt%, of the rigid thermoplastic phase is  
25           chemically grafted to the rubber phase and from 10 to 90 wt%, preferably from 40 to 75 wt% of the rigid thermoplastic phase remains "free, i.e., non-grafted.

The rigid thermoplastic phase of the rubber modified thermoplastic resin may be formed: (i) solely by polymerization carried out in the presence of the rubber phase or (ii) by addition of one or more separately polymerized rigid thermoplastic polymers to a rigid thermoplastic polymer that has been  
5 polymerized in the presence of the rubber phase.

In a preferred embodiment, one or more separately polymerized rigid thermoplastic polymers is grafted to a rigid thermoplastic polymer that has been polymerized in the presence of the rubber phase in order to aid in adjusting the viscosity of the composition of the present invention into the  
10 desired range. In a more highly preferred embodiment, the weight average molecular weight of the one or more separately polymerized rigid thermoplastic polymers is from about 50,000 to about 100,000 g/mol.

In a preferred embodiment, the rubber modified thermoplastic resin comprises a rubber phase comprising a polymer having structural units  
15 derived from one or more conjugated diene monomers, and, optionally, further comprising structural units derived from one or more monomers selected from vinyl aromatic monomers and monoethylenically unsaturated nitrile monomers, and the rigid thermoplastic phase comprises a polymer having structural units derived from one or more monomers selected from  
20 vinyl aromatic monomers and monoethylenically unsaturated nitrile monomers.

In a highly preferred embodiment, the rubber phase of the rubber modified graft copolymer comprises a polybutadiene or poly(styrene-butadiene) rubber and the rigid phase comprises a styrene-acrylonitrile  
25 copolymer.

Each of the polymers of the rubber phase and of the rigid thermoplastic resin phase of the rubber modified thermoplastic resin may, provided that the

T<sub>g</sub> limitation for the respective phase is satisfied, optionally include structural units derived from one or more other copolymerizable monoethylenically unsaturated monomers such as, e.g., monoethylenically unsaturated carboxylic acids such as, e.g., acrylic acid, methacrylic acid, itaconic acid, hydroxy(C<sub>1</sub>-C<sub>12</sub>)alkyl (meth)acrylate monomers such as, e.g., hydroxyethyl methacrylate; (C<sub>4</sub>-C<sub>12</sub>)cycloalkyl (meth)acrylate monomers such as e.g., cyclohexyl methacrylate; (meth)acrylamide monomers such as e.g., acrylamide and methacrylamide; maleimide monomers such as, e.g., N-alkyl maleimides, N-aryl maleimides, maleic anhydride, vinyl esters such as, e.g., vinyl acetate and vinyl propionate. As used herein, the term "(C<sub>4</sub>-C<sub>12</sub>)cycloalkyl" means a cyclic alkyl substituent group having from 4 to 12 carbon atoms per group and the term "(meth)acrylamide" refers collectively to acrylamides and methacrylamides.

In a preferred embodiment, the rubber phase of rubber modified thermoplastic resin has a particle size of from 0.1 to 3.0 micrometers ("μm") more preferably from 0.2 to 2.0 μm.

In a preferred embodiment, the composition of the present invention includes a fluoropolymer, in an amount, typically from 0.01 to 1.0 pbw fluoropolymer per 100 pbw of the thermoplastic resin composition, that is effective to provide anti-drip properties to the resin composition. Suitable fluoropolymers and methods for making such fluoropolymers are known, see, e.g., U.S Patent Nos. 3,671,487, and 3,723,373. Suitable fluoropolymers include homopolymers and copolymers that comprise structural units derived from one or more fluorinated α-olefin monomers. The term "fluorinated α-olefin monomer" means an α-olefin monomer that includes at least one fluorine atom substituent. Suitable fluorinated α-olefin monomers include, e.g., fluoroethylenes such as, e.g., CF<sub>2</sub>=CF<sub>2</sub>, CHF=CF<sub>2</sub>, CH<sub>2</sub>=CF<sub>2</sub>, CH<sub>2</sub>=CHF, CClF=CF<sub>2</sub>, CCl<sub>2</sub>=CF<sub>2</sub>, CCIF=CCIF, CHF=CCl<sub>2</sub>, CH<sub>2</sub>=CClF, and

$\text{CCl}_2=\text{CClF}$  and fluoropropylenes such as, e.g.,  $\text{CF}_3\text{CF}=\text{CF}_2$ ,  $\text{CF}_3\text{CH}=\text{CHF}$ ,  
 $\text{CF}_3\text{CH}=\text{CF}_2$ ,  $\text{CF}_3\text{CH}=\text{CH}_2$ ,  $\text{CF}_3\text{CF}=\text{CHF}$ ,  $\text{CHF}_2\text{CH}=\text{CHF}$  and  $\text{CF}_3\text{CF}=\text{CH}_2$ . In  
a preferred embodiment, the fluorinated  $\alpha$ -olefin monomer is one or more of  
5 tetrafluoroethylene ( $\text{CF}_2=\text{CF}_2$ ), chlorotrifluoroethylene ( $\text{CClF}=\text{CF}_2$ ),  
vinylidene fluoride ( $\text{CH}_2=\text{CF}_2$ ) and hexafluoropropylene ( $\text{CF}_2=\text{CFCF}_3$ ).

Suitable fluorinated  $\alpha$ -olefin homopolymers include e.g., poly(tetra-  
fluoroethylene), poly(hexafluoroethylene).

Suitable fluorinated  $\alpha$ -olefin copolymers include copolymers  
comprising structural units derived from two or more fluorinated  $\alpha$ -olefin  
10 copolymers such as, e.g., poly(tetrafluoroethylene-hexafluoroethylene), and  
copolymers comprising structural units derived from one or more  
fluorinated monomers and one or more non-fluorinated monoethylenically  
unsaturated monomers that are copolymerizable with the fluorinated  
monomers such as, e.g., poly(tetrafluoroethylene-ethylene-propylene)  
15 copolymers. Suitable non-fluorinated monoethylenically unsaturated  
monomers include e.g.,  $\alpha$ -olefin monomers such as, e.g., ethylene, propylene  
butene, acrylate monomers such as e.g., methyl methacrylate, butyl acrylate,  
vinyl ethers, such as, e.g., cyclohexyl vinyl ether, ethyl vinyl ether, n-butyl  
vinyl ether, vinyl esters such as, e.g., vinyl acetate, vinyl versatate.

20 In a preferred embodiment, the fluoropolymer particles range in size  
from 50 to 500 nm, as measured by electron microscopy.

In a preferred embodiment, the fluoropolymer is a  
poly(tetrafluoroethylene) homopolymer ("PTFE").

25 Since direct incorporation of a fluoropolymer into a thermoplastic resin  
composition tends to be difficult, it is preferred that the fluoropolymer be pre-



blended in some manner with a second polymer, such as for, example, an aromatic polycarbonate resin or a styrene-acrylonitrile resin. For example, an aqueous dispersion of fluoropolymer and a polycarbonate resin may be steam precipitated to form a fluoropolymer concentrate for use as a drip inhibitor additive in thermoplastic resin composition, as disclosed in, for example, U.S. Patent No. 5,521,230, or, alternatively, an aqueous styrene-acrylonitrile resin emulsion or an aqueous acrylonitrile-butadiene-styrene resin emulsion and then precipitating and drying the co-coagulated fluoropolymer-thermoplastic resin composition to provide a PTFE-thermoplastic resin powder as disclosed in, for example, U.S Patent No. 4,579,906.

In another embodiment, the fluoropolymer additive comprises from 30 to 70 wt%, more preferably 40 to 60 wt%, of the fluoropolymer and from 30 to 70 wt%, more preferably 40 to 60 wt%, of the second polymer.

In another embodiment, a fluoropolymer additive is made by emulsion polymerization of one or more monoethylenically unsaturated monomers in the presence of the aqueous fluoropolymer dispersion utilized in the present invention to form a second polymer in the presence of the fluoropolymer. Suitable monoethylenically unsaturated monomers are disclosed above. The emulsion is then precipitated, e.g., by addition of sulfuric acid. The precipitate is dewatered, e.g., by centrifugation, and then dried to form a fluoropolymer additive that comprises fluoropolymer and an associated second polymer. The dry emulsion polymerized fluoropolymer additive is in the form of a free-flowing powder.

In another embodiment, the monoethylenically unsaturated monomers that are emulsion polymerized to form the second polymer comprise one or more monomers selected from vinyl aromatic monomers, monoethylenically unsaturated nitrile monomer and (C<sub>1</sub>-C<sub>12</sub>)alkyl (meth)acrylate monomers.

Suitable vinyl aromatic monomers, monoethylenically unsaturated nitrile monomer and (C<sub>1</sub>-C<sub>12</sub>)alkyl (meth)acrylate monomers are disclosed above.

5 In a highly preferred embodiment, the second polymer comprises structural units derived from styrene and acrylonitrile. More preferably, the second polymer comprises from 60 to 90 wt% structural units derived from styrene and from 10 to 40 wt% structural units derived from acrylonitrile.

The emulsion polymerization reaction mixture may optionally include emulsified or dispersed particles of a third polymer, such as, e.g., an emulsified butadiene rubber latex.

10 The emulsion polymerization reaction is initiated using a conventional free radical initiator, as disclosed above with respect to the rubber modified graft copolymer.

15 A chain transfer agent such as, e.g., a (C<sub>9</sub>-C<sub>13</sub>) alkyl mercaptan compound such as nonyl mercaptan, t-dodecyl mercaptan, may, optionally, be added to the reaction vessel during the polymerization reaction to reduce the molecular weight of the second polymer. In a preferred embodiment, no chain transfer agent is used.

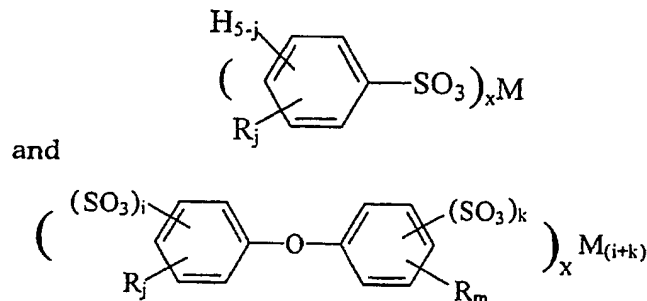
20 In another embodiment, the stabilized fluoropolymer dispersion is charged to a reaction vessel and heated with stirring. The initiator system and the one or more monoethylenically unsaturated monomers are then charged to the reaction vessel and heated to polymerize the monomers in the presence of the fluoropolymer particles of the dispersion to thereby form the second polymer.

25 Suitable fluoropolymer additives and emulsion polymerization methods are disclosed in EP 0 739 914 A1.

In a preferred embodiment, the second polymer exhibits a weight average molecular weight of from about 10,000 to about 200,000 g/mol.

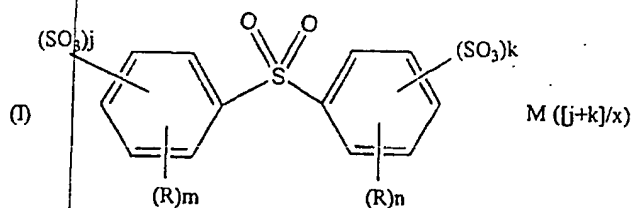
Flame Retardant. When polycarbonate and ABS rubbers are compounded together to produce a composition comprising both thermoplastic materials, the flammability of the resulting mixture increases dramatically. It has unexpectedly been found that salts of substituted benzenesulfonic acids act as flame retardant materials for such compositions.

Accordingly the compositions of the present invention comprise a flame retarding amount of a salt of a substituted aromatic sulfonic acid. In one embodiment, the flame retardant is a salt of a substituted aromatic sulfonic acid selected from the group consisting of:



where R is independently for each substitution a one to forty carbon atom alkyl, aralkyl or aromatic group, M is a metal selected from the group of alkali metals and alkaline earth metals with x the oxidation state of the metal, M, where i, j, k and m are each integers ranging from 0 to 5 subject to the limitation that i + k is at least 1 and subject to the further limitation that i + j is less than or equal to 5 and k + m is less than or equal to 5. Preferably R is an alkyl group having from 3 to 22 carbon atoms, more preferably 8 to 14 carbon atoms and most preferably 12 carbon atoms.

In another embodiment, the flame retardant is a salt of an aromatic sulfone sulfonic acid of the formula:



wherein M is a metal selected from the group of alkali metals and alkaline earth metals with x the oxidation state of the metal; R is independently for each substitution a one to forty carbon atom alkyl, aralkyl or aromatic group; and j, k, m and n are each integers ranging from 0 to 5 subject to the limitation that j + k is at least 1 and subject to the further limitation that j + m is less than or equal to 5 and k + n is less than or equal to 5.

In one embodiment, the metals are selected from the group consisting of periodic table Group IA and Group IIA metals, more preferred metals are selected from the group consisting of Group IA metals and the most preferred metal is sodium.

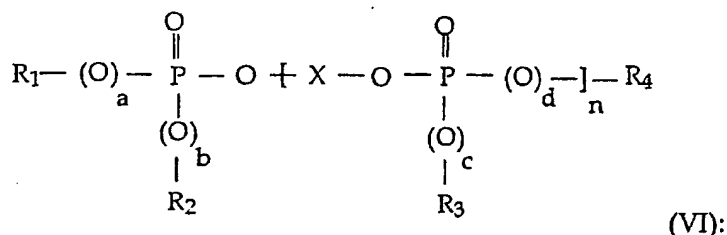
While the present invention, in some of the embodiments, is directed to diphenylsulfonesulfonic acid salts, benzenesulfonic acid salts and diphenylether sulfonic acid salts of alkali metal and alkaline earth metals, other aromatic centers that can be substituted by an alkyl group and that can be sulfonated to form homologous sulfonic acids may also be used, e.g. other fused ring aromatic systems.

In contrast to other sulfonic acid salts with electron withdrawing groups, the present invention utilizes sulfonates where the aromatic centers possess one or more electron donating groups. When the aromatic sulfone sulfonic acid salts or alkyl-benzenesulfonic acid salts are incorporated into a polymer for a flame retarding effect generally an amount effective to produce a retardation in combustion is employed. This amount ranges from about 0.01 weight percent to about 5.0 weight percent of the total composition, more

preferably from about 0.02 weight percent to about 1.0 weight percent of the total composition, and most preferably from about 0.05 weight percent to about 0.15 weight percent of the total composition.

5 Additionally organophosphorus compounds may be suitable as an added flame retardant for the compositions of the present invention. Known compounds including monophosphate esters such as, for example, triphenyl phosphate, tricresyl phosphate, tritolyl phosphate, diphenyl  
 10 tricresylphosphate, phenyl bisdodecyl phosphate, ethyl diphenyl phosphate, as well as diphosphate esters and oligomeric phosphates such as, for example, resorcinol diphosphate, diphenyl hydrogen phosphate, 2-ethylhexyl  
 15 hydrogen phosphate have been found to be useful. Suitable oligomeric phosphate compounds are set forth in co-assigned U.S. Patent Number 5,672,645, Eckel et al. for a "Flame Resistant Polycarbonate/ABS Moulding Compounds Resistant to Stress Cracking", the disclosure of which is hereby incorporated herein by reference.

Additionally, the organophosphorus flame retardants useful in the compositions of the present invention comprises one or more compounds according to the structural formula:



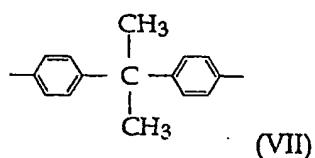
20 wherein R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub> and R<sub>4</sub> are each independently aryl, which may be optionally substituted with halo or alkyl, X is arylene, optionally substituted with halo or alkyl, a, b, c and d are each independently 0 or 1, and n is an integer of from 0 to 5, more preferably from 1 to 5.

As used herein, aryl means a monovalent radical containing one or more aromatic rings per radical, which, in the case wherein the radical contains two or more rings, may be fused rings and which may optionally be substituted on the one or more aromatic rings with one or more alkyl groups, each preferably (C<sub>1</sub>-C<sub>6</sub>)alkyl.

As used herein, arylene means a divalent radical containing one or more aromatic rings per radical, which may optionally be substituted on the one or more aromatic rings with one or more alkyl groups, each preferably (C<sub>1</sub>-C<sub>6</sub>)alkyl and which, in the case wherein the divalent radical contains two or more rings, the rings may be fused or may be joined by a non-aromatic linkages, such as for example, an alkylene, alkylidene, any of which may be substituted at one or more sites on the aromatic ring with a halo group or (C<sub>1</sub>-C<sub>6</sub>)alkyl group.

In a highly preferred embodiment, R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub> and R<sub>4</sub> are each phenyl, a, b, c and d are each 1 and X is phenylene, more preferably 1,3-phenylene.

In an alternative highly preferred embodiment, R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub> and R<sub>4</sub> are each phenyl, a, b, c and d are each 1 and X is a divalent radical according to the structural formula (VII):



In another embodiment, the organophosphorus flame retardant comprises a blend of organophosphorus oligomers, each according to formula (VI), wherein n is, independently for each oligomer, an integer from 1 to 5 and wherein the blend of oligomers has an average n of from greater than 1 to less

than 5, more preferably greater than 1 to less than 3, even more preferably greater than 1 to less than 2, still more preferably from 1.2 to 1.7.

The thermoplastic resin composition of the present invention may optionally also contain various conventional additives, such as antioxidants, such as, e.g., organophosphites, e.g., tris(nonyl-phenyl)phosphite, (2,4,6-tri-  
5 tert-butylphenyl)(2-butyl-2-ethyl-1,3-propanediol)phosphite, bis(2,4-di-tert-butylphenyl)pentaerythritol diphosphite or distearyl pentaerythritol diphosphite, as well as alkylated monophenols, polyphenols, alkylated reaction products of polyphenols with dienes, such as, e.g., butylated reaction  
10 products of para-cresol and dicyclopentadiene, alkylated hydroquinones, hydroxylated thiodiphenyl ethers, alkylidene-bisphenols, benzyl compounds, acylaminophenols, esters of beta-(3,5-di-tert-butyl-4-hydroxyphenyl)-propionic acid with monohydric or polyhydric alcohols, esters of thioalkyl or thioaryl compounds, such as, e.g., distearylthiopropionate,  
15 dilaurylthiopropionate, ditridecylthiodipropionate, amides of beta-(3,5-di-tert-butyl-4-hydroxyphenyl)-propionic acid; UV absorbers and light stabilizers such as, e.g., (i) 2-(2'-hydroxyphenyl)-benzotriazoles, 2-Hydroxy-benzophenones; (ii) esters of substituted and unsubstituted benzoic acids, (iii) acrylates, (iv) nickel compounds; sterically hindered amines such as, e.g.,  
20 triisopropanol amine or the reaction product of 2,4-dichloro-6-(4-morpholinyl)-1, 3, 5-triazine with a polymer of 1, 6-diamine, N, N'-Bis(-2, 2, 4, 6-tetramethyl-4-piperidenyl) hexane; neutralizers such as magnesium stearate, magnesium oxide, zinc oxide, zinc stearate, hydrotalcite; impact modifiers; fillers and reinforcing agents, such as, e.g., silicates, TiO<sub>2</sub>, glass  
25 fibers, carbon black, graphite, calcium carbonate, talc, mica; and other additives such as, e.g., lubricants such as, e.g., pentaerythritol tetrastearate, EBS wax, silicone fluids, plasticizers, optical brighteners, pigments, dyes, colorants, flameproofing agents; anti-static agents; and blowing agents, as

well as other flame retardants in addition to the above-disclosed organophosphorus flame retardant and fluoropolymer.

5 The thermoplastic resin composition of the present invention is made by combining and mixing the components of the composition of the present invention under conditions suitable for the formation of a blend of the components, such as for example, by melt mixing using, for example, a two-roll mill, a Banbury mixer or a single screw or twin-screw extruder, and, optionally, then reducing the composition so formed to particulate form, e.g., by pelletizing or grinding the composition.

10 The thermoplastic resin composition of the present invention can be molded into useful shaped articles by a variety of means such as injection molding, extrusion, rotational molding, blow molding and thermoforming to form articles such as, for example, computer and business machine housings, home appliances.

15 While typical embodiments have been set forth for the purpose of illustration, the foregoing descriptions and examples should not be deemed to be a limitation on the scope of the invention. Accordingly, various modifications, adaptations, and alternatives may occur to one skilled in the art without departing from the spirit and scope of the present invention.

20 Examples

For EXAMPLES 1-10 and the two comparative examples as shown in Table I, all formulations, in percent, were combined in a Henschel mixer, and compounded and pelletized on either a Welding Engineers 20 millimeter (mm) twin screw extruder or a Werner-Pfleiderer 30 mm twin screw extruder.

25 The resulting pellets were dried in a forced air oven before being molded into test specimens. The molding machine used was a 30 ton Engel injection molder operated at a nominal melt temperature of 465-515°F. Appropriate



ASTM geometry parts were molded and tested as per the ASTM protocol. The test protocol followed for flame resistance was the Underwriter's Laboratory UL94, vertical burn test where the flammability ratings are from least to most flammable, V-0, V-1, V-2 and B (burning) and part thickness was 1.5  
5 millimeters.

The components in the formulations tabulated below in Table 1 are as follows:

PC1 polycarbonate resin, General Electric,

PC2 polycarbonate resin, General Electric,

ABS, Bulk ABS, General Electric,

10 PTFE, polytetrafluoroethylene concentrate (as anti-drip), General Electric,

KSS, potassium diphenylsulfone sulfonate, Hexel

PETS, pentaerythritoltetrate, Lonza,

additive 1, hindered phenol, Ciba Geigy,

additive 2, phosphate stabilizer, Ciba Geigy.

08CY05961

TABLE 1

Example	1	2	3	4	5	6	7	8	9	10	C1	C2
Component												
PC 1	69.94	69.8	67.1	68.74	68.04	67.34	66.64	66.15	82.34	92.41	68.18	93.31
PC 2	29.96	29.95	28.9	29.46	29.16	28.86	28.56	28.35	12.88		28.64	
ABS			4	1	2	3	4	4	3.6	6	4	6
PTFE	0.25	0.25	0.25	0.5	0.5	0.5	0.5	1.0	0.6	0.75		
KSS	0.15			0.3	0.3	0.3	0.3	0.5	0.24	0.3	0.5	0.3
PETS									0.19	0.4		0.4
additive 1									0.08	0.08		0.08
additive 2									0.08	0.08		0.08
FOT*	1.8	3.1	>30	1.6	1.1	2.9	1.5	1.4	2.15	5.1	--	--
drips	0	8	12	0	0	0	0	0	0	0	drips	drips
UL94 rating	V-0	V-1	--	V-0	V-0	V-0	V-0	V-0	V-0	V-1	--	--

5 \* average flame out times for first and second burns for 10 bars

For EXAMPLES A-J as shown in Table 2, the formulations in percent are tumble blended and compounded and pelletized on a Werner-Pfleiderer 30mm twin screw extruder. Barrel temperatures were set at 530 °F using a through put of 40 kg/hr. The resulting pellets were dried for 4 hours in a forced air oven at 200 °F before being molded into test specimens. The molding machine used was an 85 ton Van Dorn with barrel and mold temperatures set at 540 °F and 170 °F respectively. The test protocol followed was the Underwriter Laboratory 94, vertical burn test where the flammability ratings are from least to most flammable, V-0, V-1, V-2 and B (burning) and part thickness is in millimeters.

The components in the formulations tabulated in Table 3 below are as follows:

- #1 polycarbonate resin, General Electric,
- #2 Bulk ABS, General Electric,
- #3 perfluorobutanesulfonate potassium salt, Bayer Corp,
- #4 polytetrafluoroethylene concentrate (as anti-drip), General Electric,
- #5 sodium dodecylbenzene sulfonate, Rhodia,
- #6 bis (dodecylsulfophenyl)ether disodium salt, Rhodia,
- #7 sodium naphthalene sulfonate, Rhodia,
- #8 pentaerythritoltetrate, Lonza,
- #9 (methylene (3,5-di-tert-butyl-4-hydroxyhydrocinnamate)) methane, hereinafter hindered phenol, Ciba Geigy;
- #10 tris (2,4-di-tert-butyl phenyl) phosphite hereinafter phosphate stabilizer, Ciba Geigy.

Table 2: Compositions of Samples Tested

Sample	A	B	C	D	E	F	G	H	I	J
Component										
1	100	100	100	95	95	94	93	100	100	100
2	-	-	-	4	4	5	6	-	-	-
3	-	0.08	-	0.1	-	-	-	-	-	-
4	-	-	-	0.8	0.8	0.8	0.8	0.8	0.8	0.8
5	-	-	-	-	-	-	-	0.3	-	-
6	-	-	0.08	-	0.1	0.1	0.1	-	0.3	-
7	-	-	-	-	-	-	-	-	-	0.3
8	-	-	-	-	-	-	-	-	-	-
9	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05
10	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1

Table 3: UL94 Ratings

Sample	A	B	C	D	E	F	G	H	I	J
Rating										
V0@3.2	(B)	V-0	V-0	-	-	-	-	-	-	-
V0@2.3	(B)	V-2	V-1	-	-	-	-	-	-	-
V0@2.0	(B)	-	-	V-0	V-0	-	-	-	-	-
V0@1.6	(B)	V-2	V-2	V-0	V-0	V-0	V-0	-	-	-
V0@1.2	-	-	-	V-1	V-0	V-0	V-1	-	-	-
V0@0.8	-	-	-	-	-	-	-	(B)	V-0	V-2

What is surprising in that while it is known in the art of the flame retardant properties of halogenated molecules in thermoplastics, as with the perfluorobutane potassium sulfate in examples B and D, in the current

invention, bis(dodecylsulfophenyl)ether disodium salt examples C, E, F, and G, is a non-halogenated molecule that is more efficient in flame retarding a polycarbonate/ABS blend.

Table 4: Increasing Flammability of PC/ABS Alloys with ABS Content

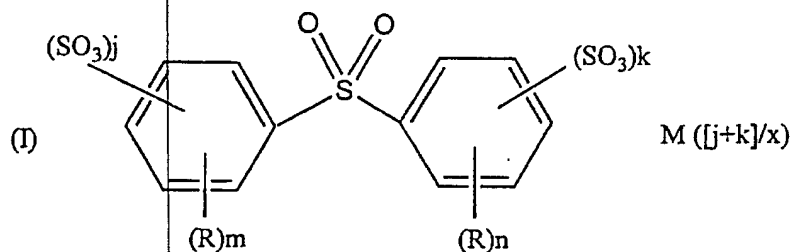
Parts by Wt. of Component	1	2	3	4
High Flow PC	100	97	94	88
Bulk ABS	0	3	6	12
Hindered phenol	0.05	0.05	0.05	0.05
Phosphate stabilizer	0.1	0.1	0.1	0.1
10 sec. Flame FOT	22.5	26.2	15.8	21.7
Flaming Drips	0	6	4	8
Notes	Self-extinguishes			

5

The data in Table 4 show that while polycarbonate self-extinguishes, the addition of ABS to the composition dramatically increases flammability, which increases with increasing ABS content.

## CLAIMS

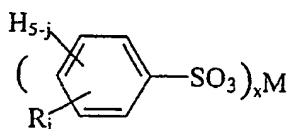
1. A thermoplastic resin composition, comprising:
  - (a) an aromatic carbonate resin,
  - (b) a rubber modified graft copolymer comprising a discontinuous rubber phase dispersed in a continuous rigid thermoplastic phase, wherein at least a portion of the rigid thermoplastic phase is chemically grafted to the rubber phase; and
  - (c) a flame retarding amount of an alkali metal or alkaline earth metal salt of an aromatic sulfonic acid compound.
2. The composition of claim 1, wherein the alkali metal or alkaline earth metal salt of an aromatic sulfonic acid compound is of the formula:



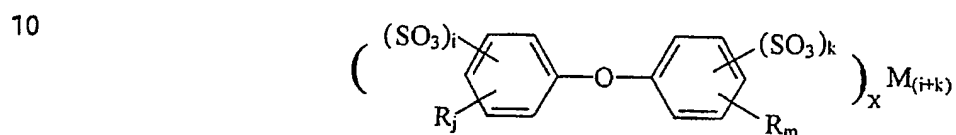
- wherein M is a metal selected from the group of alkali metals and alkaline earth metals with x the oxidation state of the metal; R is independently for each substitution a one to forty carbon atom alkyl, aralkyl or aromatic group; and j, k, m and n are each integers ranging from 0 to 5 subject to the limitation that j + k is at least 1 and subject to the further limitation that j + m is less than or equal to 5 and k + n is less than or equal to 5.

3. The composition of claim 1, wherein the alkali metal or alkaline earth metal salt of an aromatic sulfonic acid compound is selected from the group consisting of:

an alkali metal or alkaline earth metal salt of an sulfonic acid  
5 flame retardant compound selected from the group consisting  
of:



and

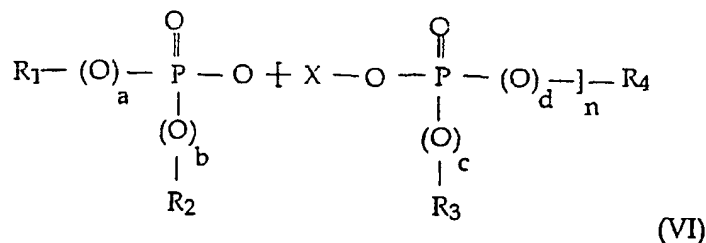


where R is independently for each substitution a one to forty carbon atom alkyl, aralkyl or aromatic group, M is a metal selected from the group of alkali metals and alkaline earth metals with x the oxidation state of the metal, M, where i, j, k and m are each integers ranging from 0 to 5 subject to the limitation that i + k is at least 1 and subject to the further limitation that i + j is less than or equal to 5 and k + m is less than or equal to 5.

20            4.        The composition of claims 1 - 3, wherein the composition comprises, based on 100 parts by weight the thermoplastic resin composition, from 40 to 96 parts by weight of the aromatic polycarbonate resin, from 4 to 59 parts by weight of the rubber modified graft copolymer and additionally from 0 to 20 parts by weight of the organophosphate flame retardant.

5. The composition of claims 1 - 4, wherein the polycarbonate resin is derived from bisphenol A and phosgene.
6. The composition of claims 1 - 5, wherein the rubber phase comprises a polybutadiene polymer or a poly(styrene-butadiene) copolymer and the rigid thermoplastic phase comprises structural units derived from one or more monomers selected from vinyl aromatic monomers and monoethylenically unsaturated nitrile monomers.
7. The composition of claim 1 - 6, wherein the rigid phase comprises a copolymer derived from monomers selected from the group consisting of styrene,  $\alpha$ -methyl styrene and acrylonitrile.
8. The composition of claim 1 - 7, wherein the rubber phase comprises a polybutadiene polymer.
9. The composition of claim 1 - 8, wherein the rigid phase comprises a copolymer of styrene and acrylonitrile.
10. The composition of claim 1 - 9, wherein the rubber phase is produced by emulsion polymerization.
11. The composition of claim 1 - 10, wherein the emulsion polymerization is carried out in the presence of an amount of a chain transfer agent effective to provide a rubber having a swell index of greater than 15.
12. The composition of claim 1 - 11, wherein the composition further comprises an organophosphorus flame retardant comprising one or more compounds according to the structural formula (VI):





wherein  $\text{R}_1$ ,  $\text{R}_2$ ,  $\text{R}_3$  and  $\text{R}_4$  are each independently aryl, which may be optionally substituted with halo or alkyl,

$\text{X}$  is arylene, optionally substituted with halo or alkyl,

5      $a$ ,  $b$ ,  $c$  and  $d$  are each independently 0 or 1, and

$n$  is an integer from 0 to 5.

13.     The composition of claim 1 - 12, wherein the composition further comprises a fluoropolymer, in an amount effective to provide anti-drip properties to the composition.

10             14.     The composition of claim 1 - 13, wherein the fluoropolymer is a tetrafluoroethylene polymer.

15             15.     The composition of claim 1 - 14, wherein the fluoropolymer is added to the composition in the form of an additive made by emulsion polymerization of one or more monoethylenically unsaturated monomers in the presence of an aqueous dispersion of the fluoropolymer.

16.     The composition of claim 1 - 15, wherein the additive is made by emulsion polymerization of styrene and acrylonitrile in the presence of an aqueous dispersion of polytetrafluoroethylene particles.

17.     An article made by molding the composition of claim 1 - 16.

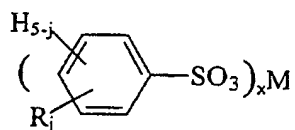
19. A thermoplastic resin composition, comprising the composition resulting from blending:

(a) a polycarbonate resin,

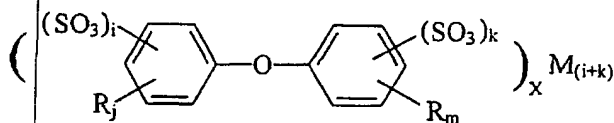
(b) a rubber modified graft copolymer comprising a discontinuous rubber phase dispersed in a continuous rigid thermoplastic phase, wherein at least a portion of the rigid thermoplastic phase is chemically grafted to the rubber phase,

(c) a flame retarding amount of an alkali metal or alkaline earth metal salt of an aromatic sulfonic acid compound selected from the group consisting of:

an alkali metal or alkaline earth metal salt of an sulfonic acid flame retardant compound selected from the group consisting of:



and



where R is independently for each substitution a one to forty carbon atom alkyl, aralkyl or aromatic group, M is a metal selected from the group of alkali metals and alkaline earth metals with x the oxidation state of the metal, M, where i, j, k and m are each integers ranging from 0 to 5 subject to the

limitation that  $i + k$  is at least 1 and subject to the further limitation that  $i + j$  is less than or equal to 5 and  $k + m$  is less than or equal to 5..

20. The composition of claim 19, wherein the composition comprises, based on 100 parts by weight the thermoplastic resin composition,
- 5 from 40 to 96 parts by weight of the aromatic polycarbonate resin, from 4 to 59 parts by weight of the rubber modified graft copolymer and additionally from 0 to 20 parts by weight of the organophosphate flame retardant.

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization  
International Bureau



(43) International Publication Date  
27 June 2002 (27.06.2002)

PCT

(10) International Publication Number  
**WO 02/050185 A3**

(51) International Patent Classification<sup>7</sup>: **C08L 69/00**,  
C08K 5/42, 5/00 // (C08L 69/00, 55:00)

(21) International Application Number: PCT/US01/51186

(22) International Filing Date:  
13 November 2001 (13.11.2001)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:  
09/742,908 20 December 2000 (20.12.2000) US  
09/742,826 20 December 2000 (20.12.2000) US

(71) Applicant: **GENERAL ELECTRIC COMPANY**  
[US/US]; 1 River Road, Schenectady, NY 12345 (US).

(72) Inventors: **BLACKBURN, Kirk, J.**; 4800 East Black-  
ford Road, Mount Vernon, IN 47620 (US). **GALLUCI,**  
**Robert, Russell**; 1109 Tanglewood Drive, Mount Vernon,  
IN 47620 (US). **GEORGIEV, Emil, Markov**; 10 Thomas  
Drive, Wyanskill, NY 12198 (US).

(74) Agents: **WINTER, Catherine, J. et al.**; General Electric  
Company, 3135 Easton Turnpike W3C, Fairfield, CT 06431  
(US).

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU,  
AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU,  
CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH,  
GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC,  
LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW,  
MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SD, SE, SG,  
SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, UZ, VN, YU,  
ZA, ZW.

(84) Designated States (*regional*): ARIPO patent (GH, GM,  
KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian  
patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European  
patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE,  
IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF,  
CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD,  
TG).

Published:  
— with international search report

(88) Date of publication of the international search report:  
13 March 2003

For two-letter codes and other abbreviations, refer to the "Guid-  
ance Notes on Codes and Abbreviations" appearing at the begin-  
ning of each regular issue of the PCT Gazette.

WO 02/050185 A3

(54) Title: FLAME RETARDANT POLYCARBONATE RESIN/ABS GRAFT COPOLYMER BLENDS

(57) Abstract: A thermoplastic resin composition contains an aromatic carbonate resin, a rubber modified graft copolymer comprising a discontinuous rubber phase dispersed in a continuous rigid thermoplastic phase, wherein at least a portion of the rigid thermoplastic phase is chemically grafted to the rubber phase, and a flame retarding amount of an alkali metal or alkaline earth metal salt of an alkylbenzenesulfonic acid flame retardant.

## INTERNATIONAL SEARCH REPORT

Inter. Application No

PCT/US 01/51186

A. CLASSIFICATION OF SUBJECT MATTER IPC 7 C08L69/00 C08K5/42 C08K5/00 //(C08L69/00,55:00)		
According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED Minimum documentation searched (classification system followed by classification symbols) IPC 7 C08K C08L		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
Electronic data base consulted during the international search (name of data base and, where practical, search terms used) EPO-Internal, WPI Data, PAJ, CHEM ABS Data		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 5 204 394 A (PRATT CHARLES F ET AL) 20 April 1993 (1993-04-20) claims 1-14 tables A, column 5, line 11-45	1,5-11, 13,14,17
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-/-		
<input checked="" type="checkbox"/> Further documents are listed in the continuation of box C. <input checked="" type="checkbox"/> Patent family members are listed in annex.		
* Special categories of cited documents : *A* document defining the general state of the art which is not considered to be of particular relevance *E* earlier document but published on or after the international filing date *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) *O* document referring to an oral disclosure, use, exhibition or other means *P* document published prior to the international filing date but later than the priority date claimed *T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention *X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art. *Z* document member of the same patent family		
Date of the actual completion of the international search 20 November 2002		Date of mailing of the international search report 05.12.02
Name and mailing address of the ISA European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040. Tx. 31 651 epo nl, Fax: (+31-70) 340-3016		Authorized officer Dury, O

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# INTERNATIONAL SEARCH REPORT

International Application No  
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## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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# INTERNATIONAL SEARCH REPORT

International application No.  
PCT/US 01/51186

## Box I Observations where certain claims were found unsearchable (Continuation of Item 1 of first sheet)

This International Search Report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:  
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claims Nos.:  
because they relate to parts of the International Application that do not comply with the prescribed requirements to such an extent that no meaningful International Search can be carried out, specifically:
3. ☐ Claims Nos.:  
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

## Box II Observations where unity of invention is lacking (Continuation of item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. ☒ As all required additional search fees were timely paid by the applicant, this International Search Report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this International Search Report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this International Search Report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

☐ The additional search fees were accompanied by the applicant's protest.

☒ No protest accompanied the payment of additional search fees.



FURTHER INFORMATION CONTINUED FROM PCT/SA/ 210

This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. Claims: 1 (part), 2,4-17

Thermoplastic composition comprising a) aromatic PC, b) rubber modified graft copolymer, c) a diphenyl sulfone sulfonic acid salt (formula I) flame retardant

2. Claims: 1 (part), 3 (part) ,4-17, 18-19\* (part)

Thermoplastic composition comprising a) aromatic PC, b) rubber modified graft copolymer, c) benzene sulfonic acid salt flame retardant

\*: the original set of claims does not contain claim #18. original claims #19-20 have been renumbered for the present reasoning as claims #18-19

3. Claims: 1 (part), 3 (part) ,4-17, 18-19\* (part)

Thermoplastic composition comprising a) aromatic PC, b) rubber modified graft copolymer, c) diphenylether sulfonic acid salt flame retardant

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Into International Application No  
PCT/US 01/51186

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